

Date: Friday, 16/05/2008 8:45:39 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STEP EXTRUSION	
<b>Job Number</b> :	39316			
<b>Estimate Number</b> :	10058			
<b>P.O. Number</b> :		<b>Part Number</b> :	D2622120C	
<b>This Issue</b> :	16/05/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2622 REV C1	
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	37754	<b>Drawing Revision</b> :	C1	
	<b>Type</b> :	<b>Material</b> :		
		<b>Due Date</b> :	05/06/2008	<b>Qty:</b> 110 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	<u>JLD 08.5.16</u>			
<b>Comment</b> :	Est. A: 02.11.12 New Issue KJ/RF			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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## Comment: PURCHASING

Issue P/O: 6389

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C208/05/20

(110)

2.0	D2622120CP	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)  
 Extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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## Comment: PACKAGING RESOURCE #1

- Receive & Inspect For Transit Damage
- Ensure material certification is attached

P-8/11

126

4.0	QC6	DIMENSIONAL CHECK
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## Comment: DIMENSIONAL CHECK

- Inspect dimension per Dwg D2622
- Check Pull test per Dwg D2622 for compliance page attached
- Check hardness with Webster tester

C0606/12

(8131)

count

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 8:45:39 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 39316

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



HALI (002)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

(54) 08/06/17

(54) +

(14) E68

(13)

(81) 08/06/13

(8R)

(14)

(15)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.06.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

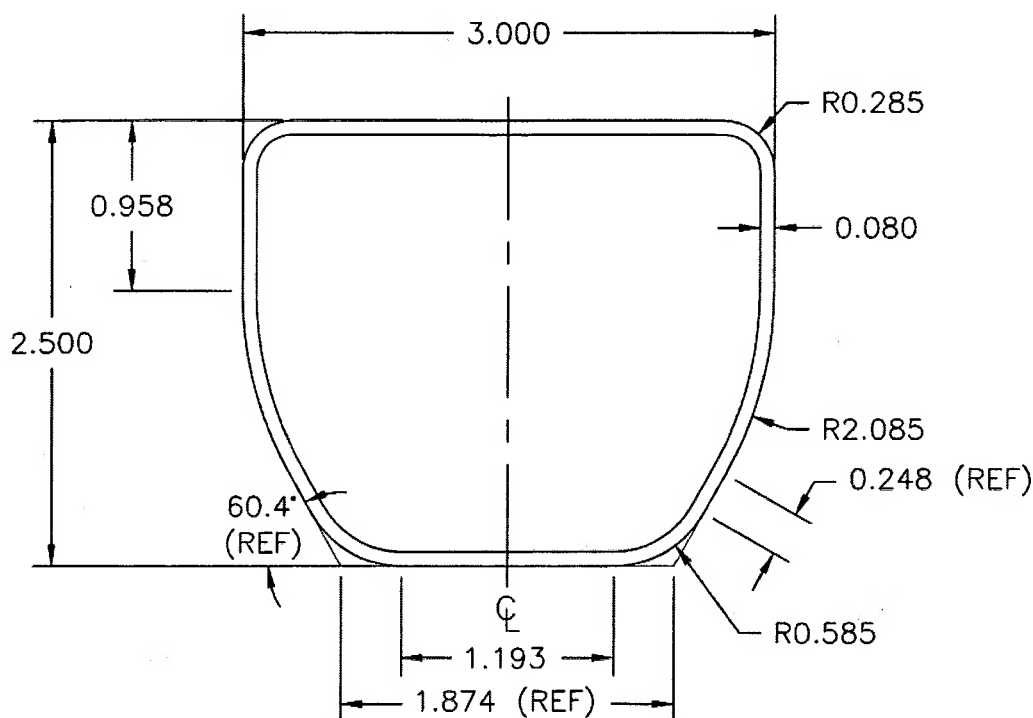
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE		DRAWN BY GP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #		APPROVED #		DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11			TITLE STEP EXTRUSION SCALE 1:1		
A	96.11.29		NEW ISSUE		
B	97.12.12		CHANGE MATERIAL, ADD TOL. QSI		
C	02.09.11		0.080 WAS 0.085; ADD PART & DIE No.		
CI	# GP	02.10.04	ADD 'REV-A' TO DIE NUMBER.		

RELEASED  
02.09.11 #



#### D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 Rev. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39316

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# CERTIFICATE OF COMPLIANCE

## SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9

Cert Date	Cert No	Sales Order	Page
06/09/08	177713	31374	1
Cust PO	B/L No	Lot	Date
6389	08379023	31374010	6/09/08

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	584 KGS
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Net Qty	554 KG	126 PC	384 M	3 PKG
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Specification	Die Desc
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AMS-QQ-A-200/8 & ASTM B221-06

### Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	314.5 / 45.6	272.4 / 39.5	11.6	.0	93

### Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.65	.35	.27	.06	.85	.06	.010	.06	.000	.009	.02	.000	.00
.64	.25	.24	.08	.85	.06	.000	.09	.000	.010	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc



ACCT# 00046024

INVOICING COMPANY AND LOCATION  
SIGNATURE ALUMINUM CANADA  
500 EDWARD AVENUE  
RICHMOND HIL ON L4C 4Y9

## SHIPPING MANIFEST

MANIFEST DATE
06-09-08
MANIFEST NUMBER
641880
SALES ORDER NUMBER
31374

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDENCECREDIT REP  
HAMBROOK, PAU  
905-508-3250

SALES REP

SHIP TO  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY ON  
K6A 1K7 CNSOLD TO / PURCHASER  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY ON  
K6A 1K7 CN

TERMS / FREIGHT

O / P

PHONE 613-632-5200

PHONE 613-632-5200

LOCATION	TRAILER NUMBER	SALESMAN	FIELD SALES REP	CUST SERVICE REP
RIH	57368	59358	Kutter A 450-435-6551	Burton D 905-427-2227
JOB				BILL OF LADING NUMBER
				08379023

CUSTOMER ID  
46024ORDER DATE  
05/28/08CUSTOMER PO NUMBER  
6389

46024	05/28/08	6389									
ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY	UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION					
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	121	KG	0	DAA-897123-1	6061 /T6	MILL	3	584	554	KG	0
		M	0	D2622	120"	CERTIFICATE OF COMP			384.05	M	0
		PC	0		+3/16 "	(+015-015,0139-0102)			126	PC	0
					-0 "						
				LOT/TKT DETAIL:		31374010 / 190929	1	246	236		56 PC
						31374010 / 190930	1	265	255		55 PC
						31374010 / 190957	1	73	63		15 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.  
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

DATE OF DELIVERY

DRIVER

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

# DART

## Purchase Order

Date May 20, 2008	Page 1
Purchase Order Number PO00006389	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

*REVISED*

### Vendor Address:



Signature Aluminum  
1850 Clements Road  
Pickering, ON L1W 3R8  
Phone (800) 563-1079  
Fax (800) 846-8885

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-BON001	May 20, 2008	N30	yours	Jun 05, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
✓ 121.0000 <i>New 126</i>	D2622120CP	Extrusion B39316 <b>Comments:</b> EXTRUDE AS PER DWG D2622 REV. C MATERIAL: 6061-T6 (QQ-A-200/8) MINIMUM YIELD TENSILE STRENGTH = 35KSI MINIMUM ULTIMATE TENSILE STRENGTH = 38KSI MINIMUM ELONGATION = 8% 120" LONG BON L CANADA INC. TOOL # 897123 REV. A TO BE PACKED PER DSK 066 PULL TEST TO ASTM STANDARD B221 REQUIRED	6/5/2008	No	28.306000	Each	3,425.03

<b>Comments:</b>  REVISED : QTY + \$	<b>Tax Summary:</b>		<b>Less:</b>  included tax	
	GST	171.25		
	GSTME	0.00		
	GSTND	0.00	Subtotal	3,425.03
	Entered By:  CLAVOIE		Total tax	171.25
Approved By: 		Total purchase order in		
		CAD Dollars	3,596.28	